

Work Order ID 77673

December-15-11 1:17:48 PM

77673

Page 1

Item ID: D4458-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel
 Start Date: 12/15/11 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/15/11 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4458	A								

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg
 Dwg Rev: B
 Prog Rev: B

2- Deburr if necessary

11-12-15

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

W

No cert
 req'd

11

Work Order ID 77673

December-15-11 1:17:48 PM

77673

Page 2

Item ID: D4458-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 12/15/11 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/15/11 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

NO CERTS REQD

W 11/12/11

Picklist Print

December-15-11 1:17:47 PM

Page 1

Work Order ID: 77673

Parent Item: D4458-3

Start Date: 12/15/11

Required Date: 12/15/11

Parent Item Name: Panel

Start Qty: 2.00

Required Qty: 2.00

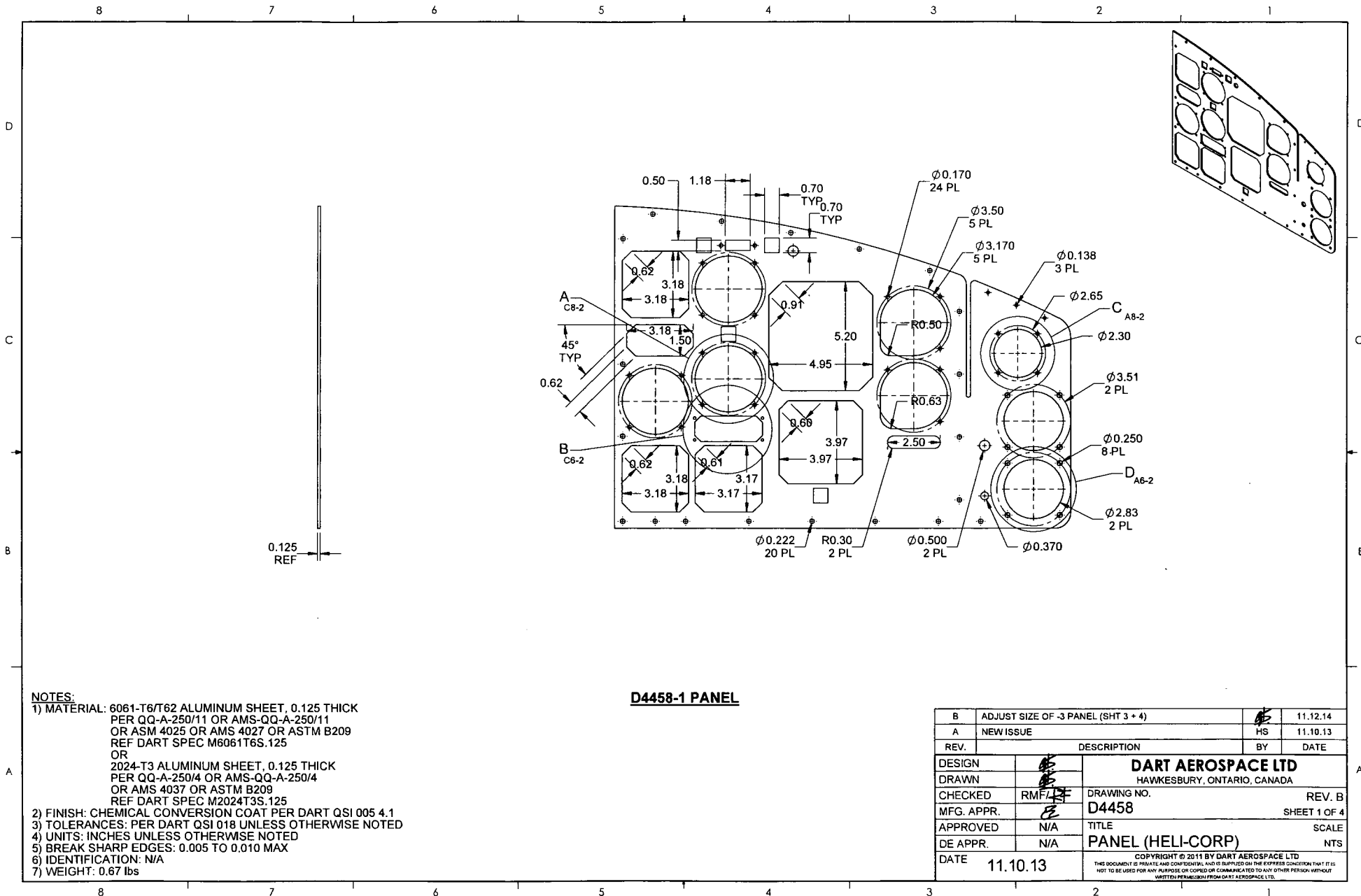
Comments: IPP REV:A 11.10.24 new issue DD verf:EC

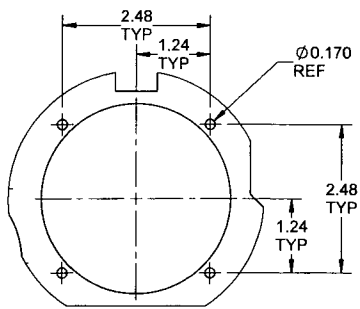
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ML EXS.125 1/8" Lexan Sheet		Purchased	No			100	sf	0.0000	1.5185	3.1968421		BH-12-5	

6061T6S12S

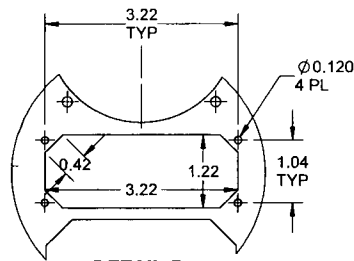
6061.125 119513

2/2

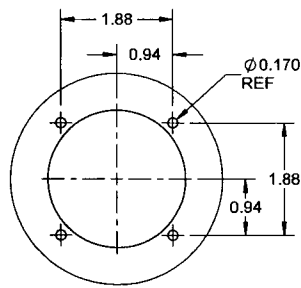




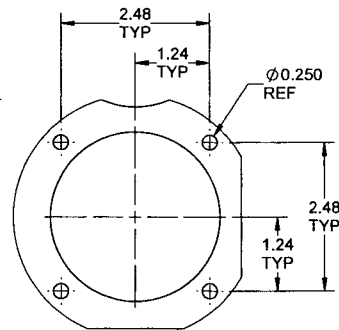
DETAIL A
SCALE 0.5X C4-1



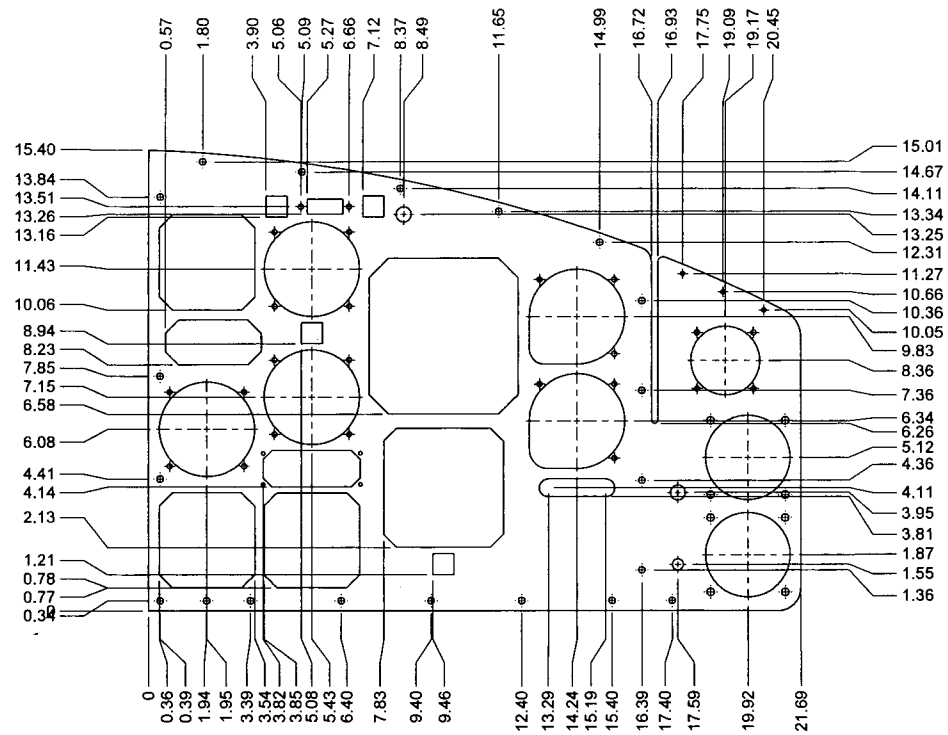
DETAIL B
SCALE 0.5X C4-1







DETAIL C
SCALE 0.5X C2-1

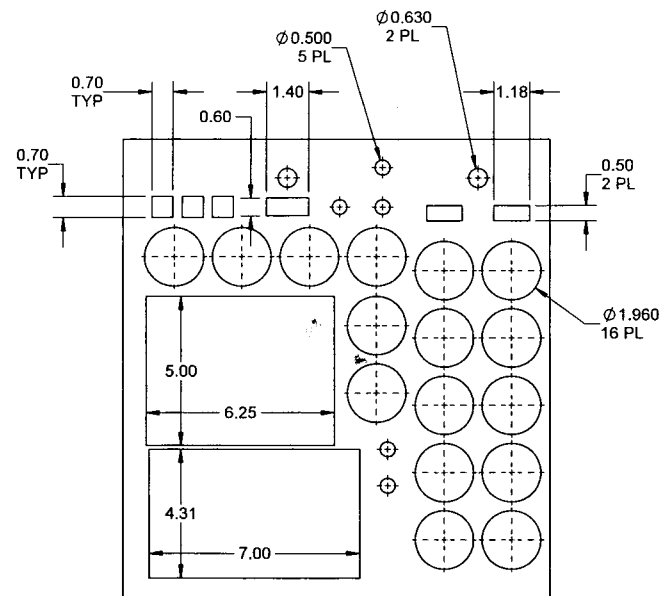


DETAIL D
SCALE 0.5X B2-1



D4458-1 PANEL
AUX VIEW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	RMF/ 	DRAWING NO.	REV. B
MFG. APPR.		D4458	SHEET 2 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	PANEL (HELI-CORP)	NTS
DATE	11.10.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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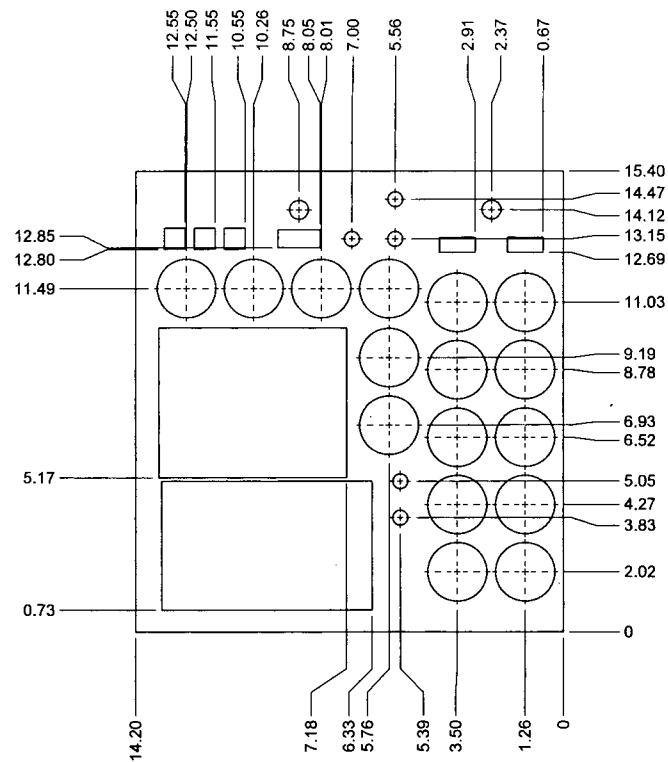


D4458-3 PANEL

NOTES:

- 1) MATERIAL: CLEAR LEXAN, 0.125 THICK
REF DART SPEC MLEXS.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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D4458-3 PANEL
AUX VIEW

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